

Date: Tuesday, 23/09/2008 10:22:04 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 42221			Part Number	: D25941	
Estimate Number	: 10178			Drawing Number	: D2594 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 23/09/2008		S.O. No. :	Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 25/10/2008
Previous Run	: 41434				Qty:	200
Written By	:			Um:	Each	
Checked & Approved By	: <u>Julie Lecocq</u>					
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
		Comment: Qty.: 0 f(s)/Unit Total : 11 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
		Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
4.0	QC8	SECOND CHECK	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
		Comment: SECOND CHECK	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">200</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 42221

Part Number: D25941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M109152



(200X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

START TIME:

11:00

OVEN TEMPERATURE:

320

FINISH TIME:

11:30

M-A

08/10/03

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(200)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/10/03

8.0 PACKAGING 1

PACKAGING RESOURCE #1



(200X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

F-P - B

M-A 08/10/06

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/06

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

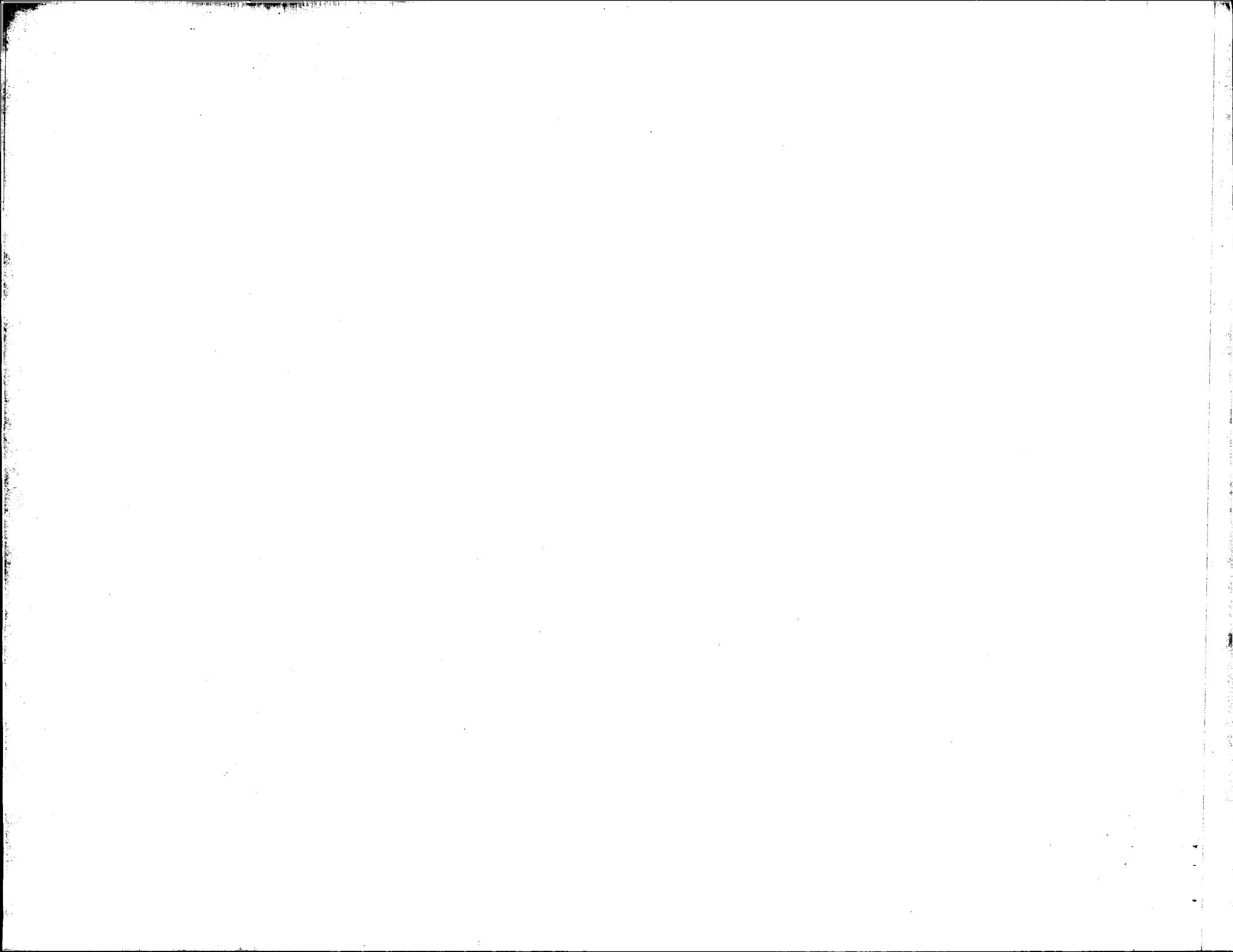
DART AEROSPACE LTD	Work Order:	42221
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>MWF</u>	Audited by: <u>JK</u>	Prototype Approval: N/A
Date: <u>08/09/28</u>	Date: <u>08/09/30</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	08.07.23	Diameter symbol added	KJ/DD	

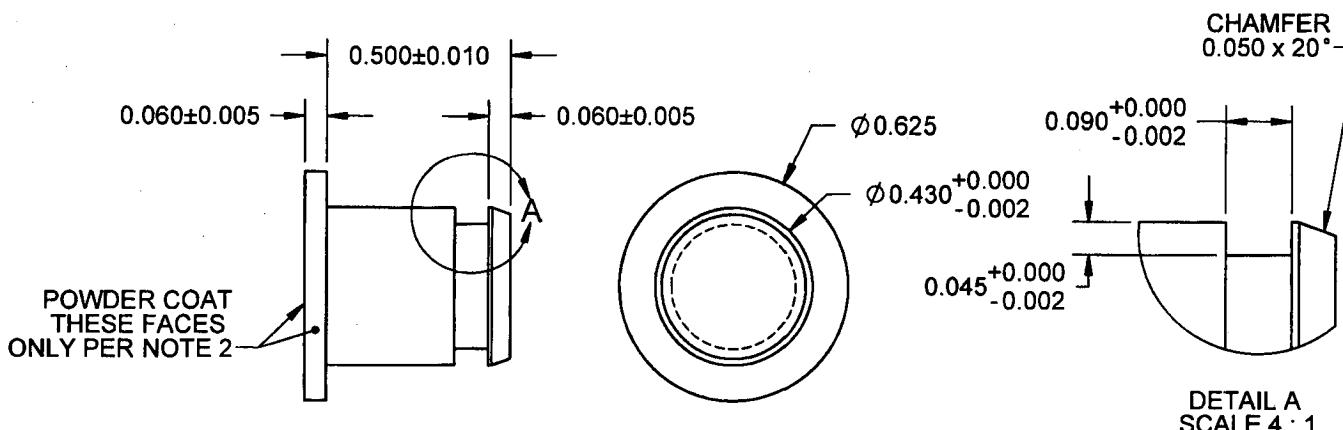


**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D2594</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.20</b>		TITLE <b>PLUG</b>	SCALE 2:1
REV <b>A</b>	DATE <b>96.09.16</b>	DESCRIPTION NEW ISSUE	

*REPLACES D2594-3**06.11.28 - CH*

REV	DATE	DESCRIPTION
<b>A</b>	<b>96.09.16</b>	NEW ISSUE
<b>B</b>	<b>97.03.15</b>	ADD GROOVE AND O-RING
<b>C</b>	<b>06.11.20</b>	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

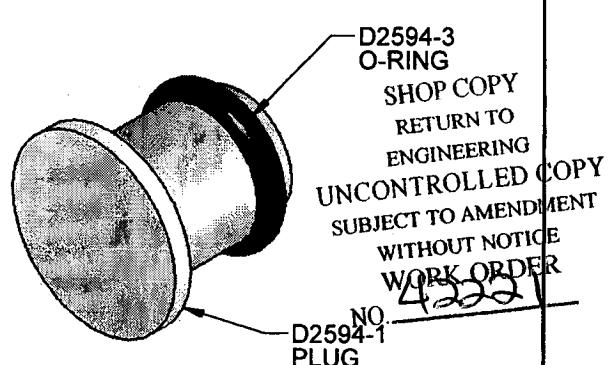
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY****COPYRIGHT © 1996 BY DART AEROSPACE LTD**

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